

Date: 03/19/18

Inspector:

Revision: 6

Serial No/Batch: S052879

Job No: 170601

Part: RBE350A94-2706-00-01A



Container No: S052879

DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada
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Plex 3/13/18 11:11 AM dart.logan.david

OML-3-23

4.9

Job BOM									
Part / Item	Component Name	Quantity	Operation	90-Start up Operation	Component Part	Required	Inventory	Allocated	Operation
88625K65	Dowel Pin Ø6mm x 40mm	24 ft (1 ea)	Operation	90-Start up Operation	88625K65	24	33	0	90-Start up Operation
Job Allocations									
Part Specifications									
Specifications could not be found.									

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Setup Run	Workcenter / Supplier	Lead Time	Sign-off	Descriptions
90	Start up Operation	24 Ea	3/10/18	0.00	0.00	Start Up Machining-3			Part Op 110 - 1-Machine as per DWG. FB734 FOLIO REV: DWG REV: 2-Debut 3-Engrave Dash
110	CNC Lathe	24 pcs	3/12/18	0.00	12.00	MORI SL-154			
120	QC	24 pcs	3/12/18	0.00	0.00	QC2 Machining-4			
130	QC	24 pcs	3/12/18	0.00	0.00	QC8 Machining-4			
140	Packaging	24 pcs	3/12/18	0.00	0.00	Packaging-3-1			
150	QC21-SA	24 Ea	3/12/18	0.00	0.00	QC21			

Bill of Materials									
Job Tracking No: Status: Scheduled									
Created By: Marie Lajeunesse									
Description:									
Note: DWG RBE350A94-2706-00 REV 6 IPP REV A 18-01-15 NEW ISSUE JFC VERIFIED DP									
Ship Via:									

Part No: RBE350A94-2706-00-01A Job Qty: 24 ea									
Part Name: Pin Shaft									
Part Weight: 0 lbs									
Job Created: 1/17/18									
Due Date: 3/12/18									
Type: SOLD									
Created By: Marie Lajeunesse									
Job Tracking No: Status: Scheduled									
Priority: High									

Job Sheet 170601									
RBE350A94-2706-00-01A									
Tel (613) 632-5200									
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Hawkesbury, ON									
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RBE350A94-2706-00-01A

Job Sheet 170601



Part No: RBE350A94-2706-00-01A

Job Qty: 24 ea

Part Name: Pin Shaft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/13/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-2706-00 REV 6 IPP REV A 18-01-15 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea		2/13/18	0.00	0.00	Start Up Machining-3		
110	CNC Lathe	24 pcs		2/13/18	0.00	12.00	MORI SL-154		
120	QC	24 pcs		2/13/18	0.00	0.00	QC2 Machining-4		
130	QC	24 pcs		2/13/18	0.00	0.00	QC8 Machining-4		
140	Packaging	24 pcs		2/13/18	0.00	0.00	Packaging3-1		
150	QC21-SA	24 Ea		2/13/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. FB734 FOLIO REV: _____ DWG REV: _____ 2-Deburr 3-Engrave Dash
Descriptions: number Using Marktronic engraver as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
88625K65	Dowel Pin Ø6mm x 40mm	24 Ea (1 ea)	90-Start up Operation	

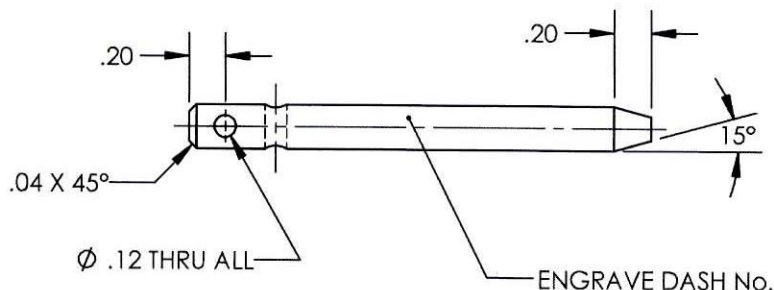
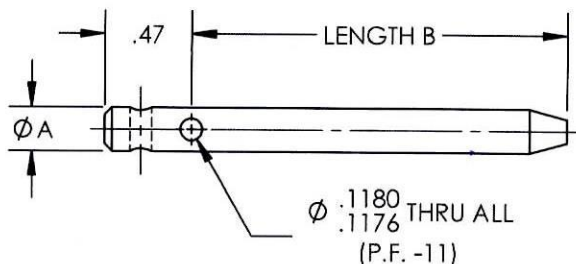
Part Specifications

Specifications could not be found.

Plex 1/17/18 11:34 AM Dart.lajeunesse.marie

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		MOVED LENGTH B DIMENSION TO Ø.118in. HOLE CENTERLINE & ADDED 1.5mm TO -.01 THRU -.09 PINS IN TABLE. ADDED A TOLERANCE TO Ø.118in HOLE TO ACHIEVE A LIGHT PRESS FIT FOR -.11. CH'D HOLE FROM Ø.118 TO Ø.113 FOR CABLE TIES. END OF PIN PER S.E.	5/26/2015	RJC	RW
4	15-0120	CH'D TOLERANCE BLOCK WAS .XXX ± .004 IS .XXX ± .005.	5/26/2015	DPD	JAG
6	16-0281	-01A, -03A, -05A, -07A, -09A CH'D DIM WAS 2X Ø.118 +.001/-0.000 THRU ALL IS Ø.1180/.1176 THRU ALL (P.F. -.11). ADDED DIM Ø.12 THRU ALL. ADDED ENGRAVE DASH No., ADDED ENGRAVE DASH No. COLUMN TO TABLE.	1/12/2017	RJC	JAG



-01A, -03A, -05A, -07A, -09A

PIN SHAFT

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 170601 MLS
1801-18

ENGRAVE	PIN DIMENSION TABLE		
DASH No.	P/N	ØA	LENGTH B
<u>-01</u>	-01A	6mm	2.028
-03	-03A	8mm	5.177
-05	-05A	8mm	3.012
-07	-07A	6mm	4.783
-09	-09A	8mm	1.240

DART AEROSPACE	
TITLE RIGGING PIN SET	
DWG NO. RBE350A94-2706-00-01A	REV 6
MAT'L O-1	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -01, -03, -05, -07, -09	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:1	DATE 9/11/2009
SHEET 3 OF 3	

OAL 2.498

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								